

Work Order ID 134335

Wednesday, July 08, 2015 3:09:56 PM

134335

RUSH

Page 1

Item ID: D2199-31 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Details
 Start Date: 7/07/15 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: JUL 09 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2199	F

110	NC BRAKE	0.00				4	FF	JUL 09 2015
110								
Brake NC	Memo	0.00						
Brake NC	Punch per Dwg D2199 and Spec Control Dwg D2638							
	Deburr							

120	QC5- Inspect part completeness to step on W/O	0.00						
120								
QC	Memo	0.00						
Quality Control								

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00						
130								
Powdercoat	Memo	0.00						
Powder Coating	START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>200</u>							
	FINISH TIME: <u>9:30</u>							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Picklist Print

Wednesday, July 08, 2015 3:09:56 PM

Page 1

Work Order ID: 134335

134335

Parent Item: D2199-31

D2199-31

Parent Item Name: Strut Details

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 15.02.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.049

Purchased

No

f

160.9300

5.473684

M304TR0 750W 049

JUL 09 2015

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

GA002

80.93

M128084

4

M129363

3.5

M130292

0.51

M132270

72.92

MAT

80

M132562

80

5.4736

DQA: _____ Date: _____

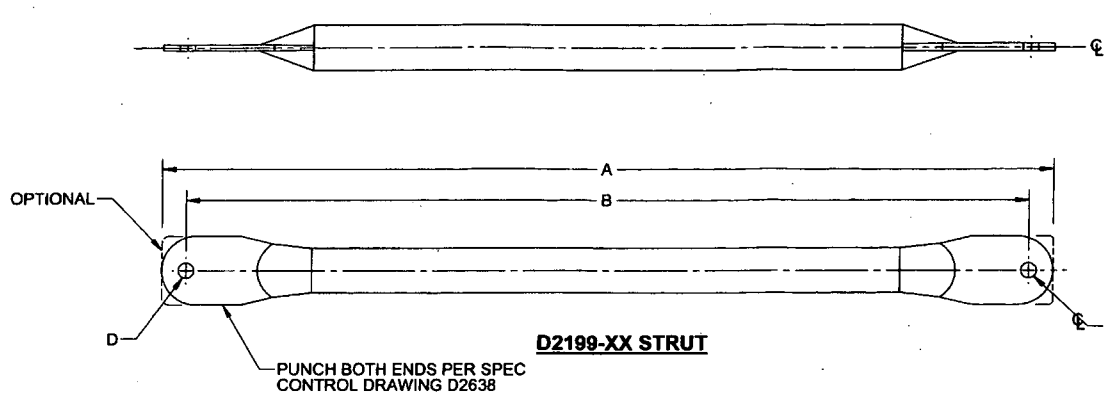


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

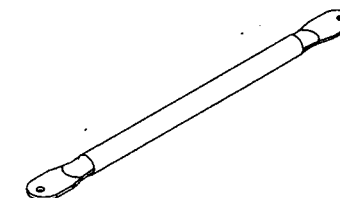
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.30	17.50	Ø 0.257	Ø 0.257	0.58	NOTE 2
D2199-3	5.80	5.00	Ø 0.257	Ø 0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø 0.257	Ø 0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø 0.257	Ø 0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø 0.257	Ø 0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø 0.257	Ø 0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø 0.257	Ø 0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø 0.257	Ø 0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø 0.257	Ø 0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø 0.257	Ø 0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø 0.257	Ø 0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø 0.257	Ø 0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø 0.257	Ø 0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø 0.257	Ø 0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø 0.257	Ø 0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø 0.257	Ø 0.257	0.45	NOTE 3

NOTES:

- MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø 0.750 X 0.049 WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF DART SPEC. M304TR0.750W0.049
- FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX PER QSI 044, 6.5.
- WEIGHT: PER CHART
- MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.



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NOTICE
ORDER

13.4.335-ML5
1507-09

RELEASED

2015 FEB 04

ECN 15-522 95-522

F	INCORPORATED E1, REFORMATTED AND REDRAWN. ADDED -31, ADDED GREY SANDTEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A565M, ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D2199	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT DETAILS	NTS
DATE	14.09.26	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

